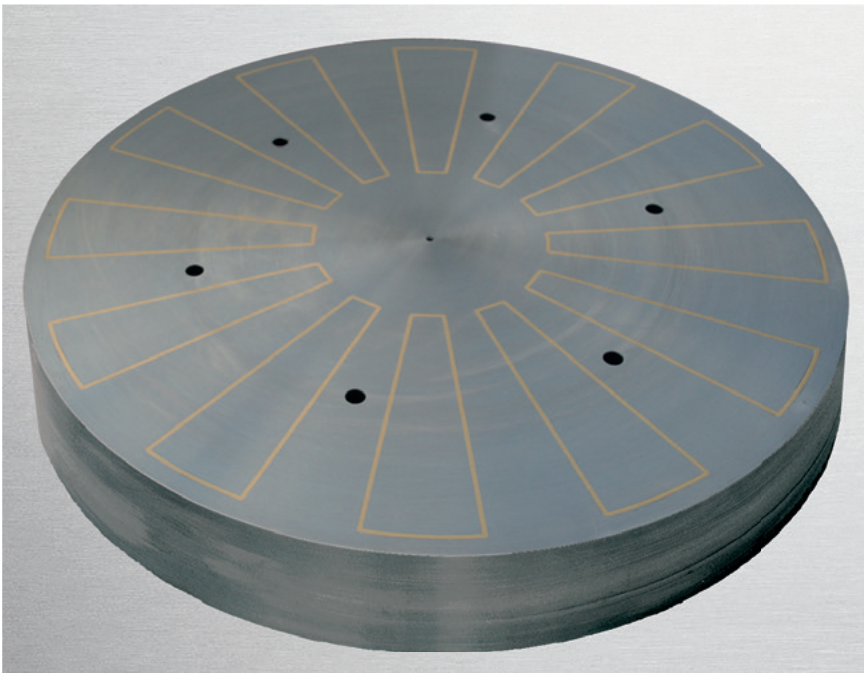


Electro-Permanent-Magnet-Clamping-Chuck



Holding force control:

If necessary, the adhesive force can be controlled via pole reversal control unit using a coding switch. This prevents deforming of the workpieces.

Versions:

- T-slots in the pole plate for screwing on pole shoes or stops
- Threaded holes in the pole plate for fastening pole strips
- Locating holes in the pole surface for centering flanges
- Pluggable socket on the outer surface
- Power transmission via flat or flanged slip rings

Design:

- Protection class IP 67 (except electrical connection)
- Magnet operating time: 100 %

Electro-Permanent-Magnet-Clamping-Chuck Type 1210V with radial pole pitch and increased adhesive force are particularly suited for central clamping of rings, flanges, bearing housings and similar rotation-symmetric components

Wherever maximum adhesive forces are needed, e.g. to bridge air gaps in uneven workpieces, when applying pole extensions or for magnetically critical materials, this reinforced construction is the first choice.

Electro permanent magnet clamping chucks are mainly used for circular grinding, turning and milling in processing centres.

Optimal accuracy is achieved by energy-aware magnetising of the clamping chuck via a precise electrical impulse. Then the

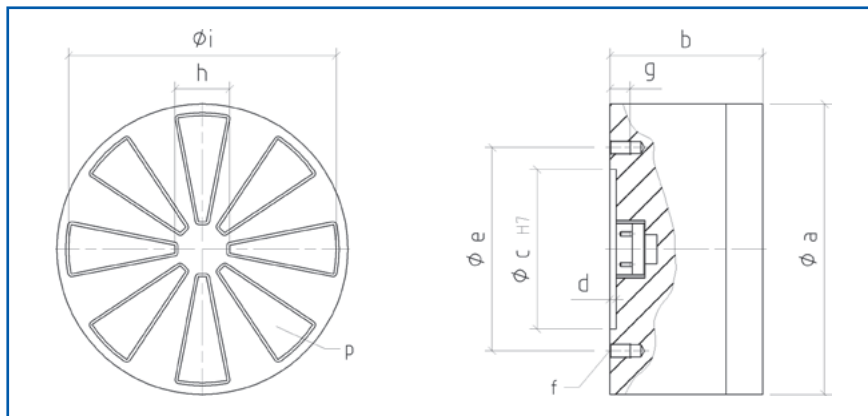
magnet is disconnected from power and therefore particularly suited for machining tasks within the μm -range.

The radial pole arrangement is suitable for separating work-pieces by using pole shoes. This separation is used as run-out range for the grinding wheel in the inside and outside area. Thus the workpiece can be machined on all three sides with optimal form and position tolerances using only on chucking

One special field of application of this clamping system is the hard turning of ball bearing races. This process involves the bearing ring being clamped over pole shoes or directly onto the Electro-Permanent-Magnet-Clamping-Chuck. A corresponding form radius is provided as run-out range for the hard-turning tool.

Electrical connection via:

Electronic pole-reversal control units. These devices, designed especially for controlling clamping magnets, function to facilitate the power supply and simultaneously as demagnetisation devices. A microprocessor controls and monitors all functions and offers optimal switching comfort with numerous control and monitoring functions. The adhesive force is adjustable in up to 16 stages. In addition, these pole-reversal control units also allow additional configuration of parameters and optimised settings. All device types offer particularly impressive shifting dynamics.



Electro-Permanent-Magnet-Clamping-Chuck

Type 1210V

with radial pole spacing and increased holding force

Characteristics:

- Highest level of precision -
- Activated magnet remains cold.
- Highest level of safety -
- Holding force even after power failure.
- Energy-conscious -
- Power used only for short pulses.

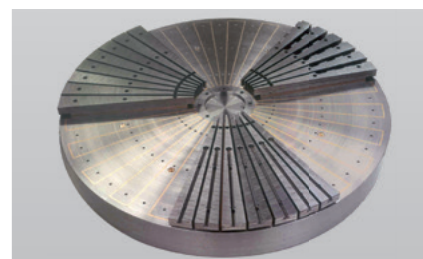
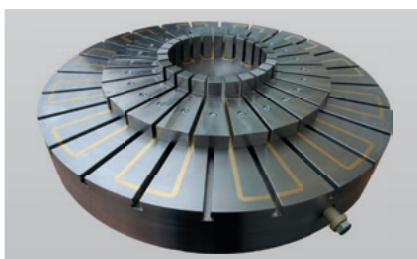
Dimensions and technical data:

Type	p No. of pole pairs	a [mm]	b [mm]	c [mm]	d [mm]	e [mm]	f Thread	g [mm]	h non-magn. zone [mm]	i [mm]	Weight [kg]	Connection value Pole-reversal control unit [V/A]*
1210V-20	6	200	110	110	3	140	4xM10	14	20	178	24	210/10
1210V-30	8	300	110	160	3	190	4xM12	16	58	270	54	210/30
1210V-40	8	400	110	210	4	250	6xM12	16	80	350	97	360/30
1210V-50	8	500	110	280	4	320	6xM12	16	113	452	151	360/30
1210V-60	8	600	120	350	4	390	6xM16	18	113	552	238	360/30
1210V-70	8	700	127	400	4	450	6xM16	18	113	648	342	360/30
1210V-80	12	800	132	450	4	500	6xM16	18	216	751	465	360/30
1210V-90	12	900	137	500	4	560	8xM16	18	216	848	610	360/60
1210V-100	12	1000	137	550	4	620	8xM16	18	216	944	753	360/60
1210V-110	12	1100	147	Backside as agreed					300	1040	978	360/60
1210V-120	12	1200	147	Backside as agreed					300	1138	1164	360/60
1210V-125	14	1250	147	Backside as agreed					300	1194	1263	360/60
1210V-140	16	1400	152	Backside as agreed					300	1344	1638	360/60x2
1210V-150	16	1500	152	Backside as agreed					400	1450	1880	360/60x2
1210V-160	16	1600	152	Backside as agreed					500	1540	2140	360/60x2
1210V-180	16	1800	162	Backside as agreed					500	1740	2886	360/60x2
1210V-200	16	2000	175	Backside as agreed					500	1942	3848	360/60x2
1210V-230	16	2300	187	Backside as agreed					500	2240	5439	360/60x2

Other dimensions and number of pole pairs are available upon request

Special Solutions:

- magnet clamping chuck with adjustable pole shoes
- magnet clamping chuck with different pole strips



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